

Work Order ID 115109

115109

Page 1

Monday, March 17, 2014 2:46:11 PM

Item ID: D3213-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Door Panel
Start Date: 3/17/14 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 3/17/14 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: MLS Date: 4-03-19 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr | | | | | | | | |
|----------|--------------|--|--|--|--|--|--|--|-------------------|
| D3213 | B | | | | | | | | DAS 23 9-89 |

100 FLOW WATER JET 0.00
100
Waterjet Memo 0.00
FLOW CNC Waterjet 1-Cut as per Dwg D3213 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
QC Memo 0.00
Quality Control

120 QCS- Inspect parts - second check 0.00
120
QC Memo 0.00
Quality Control

DC 14/08/21

DC 14/08/21

8 DAS 38 14-8-21

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
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Work Order ID 115109

Monday, March 17, 2014 2:46:11 PM

115109

Page 2

Item ID: D3213-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Door Panel
Start Date: 3/17/14 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 3/17/14 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | | 0.00 | | | | | | | |
| *130* | Small Fab | | | DAS | | | | | |
| Small Fab | Memo | 0.00 | | 30 | | | | | |
| Small Fab | Deburr | | | 9-89 | | | | | |
| | | | | N/A | | | | | |
| 140 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |
| | | | | | | | | | |
| 150 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

68 7/15/14-8:25

6 2 (OP) 14/08/25

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
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| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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|--|--|---|---|
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|--|--|---|---|

Work Order ID 115109

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115109

Page 3

Item ID: D3213-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door Panel

Start Date: 3/17/14

Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/17/14

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: _____

0.00

160

Packaging

Memo

57487

0.00

Packaging

14/8/20

6

DAS
32
9-89

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MLJ 14-08-25

MLJ 14-08-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
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| Doc/Data | | | | | | | | | |
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| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
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| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
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FAULT CATEGORY

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| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____ |
|--|--|---|---|

Picklist Print

Monday, March 17, 2014 2:46:10 PM

Page 1

Work Order ID: 115109

115109

Parent Item: D3213-1

D3213-1

Parent Item Name: Door Panel

Start Date: 3/17/14

Required Date: 3/17/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 05-11-17 New Issue JLM
 IPP Rev:B 07-02-13 Now on Waterjet JLM
 IPP Rev C: 08.11.26 Comment added to step 2 KJ Verified by: EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|-----------------------|--|-----------|--|----|--|-----|----|----------|-----------|---------------------|--|--|-------------|
| M2024T3S.063 | | Purchased | | No | | 100 | sf | 302.4339 | 0.4714 | 2.977263 | | | DAS |
| *M2024T3S 063* | | | | | | | | | ** | 3 | | | 23 |
| 2024-T3 .063 sheet | | | | | | | | | | | | | 9-89 |

| Location | Loc Qty | Loc Code |
|----------|----------|----------|
| MAT022 | 302.4339 | |
| 123701 | 16.1039 | |
| m127866 | 94.33 | |
| m128354 | 192 | |

130000

130000 .

14-08-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

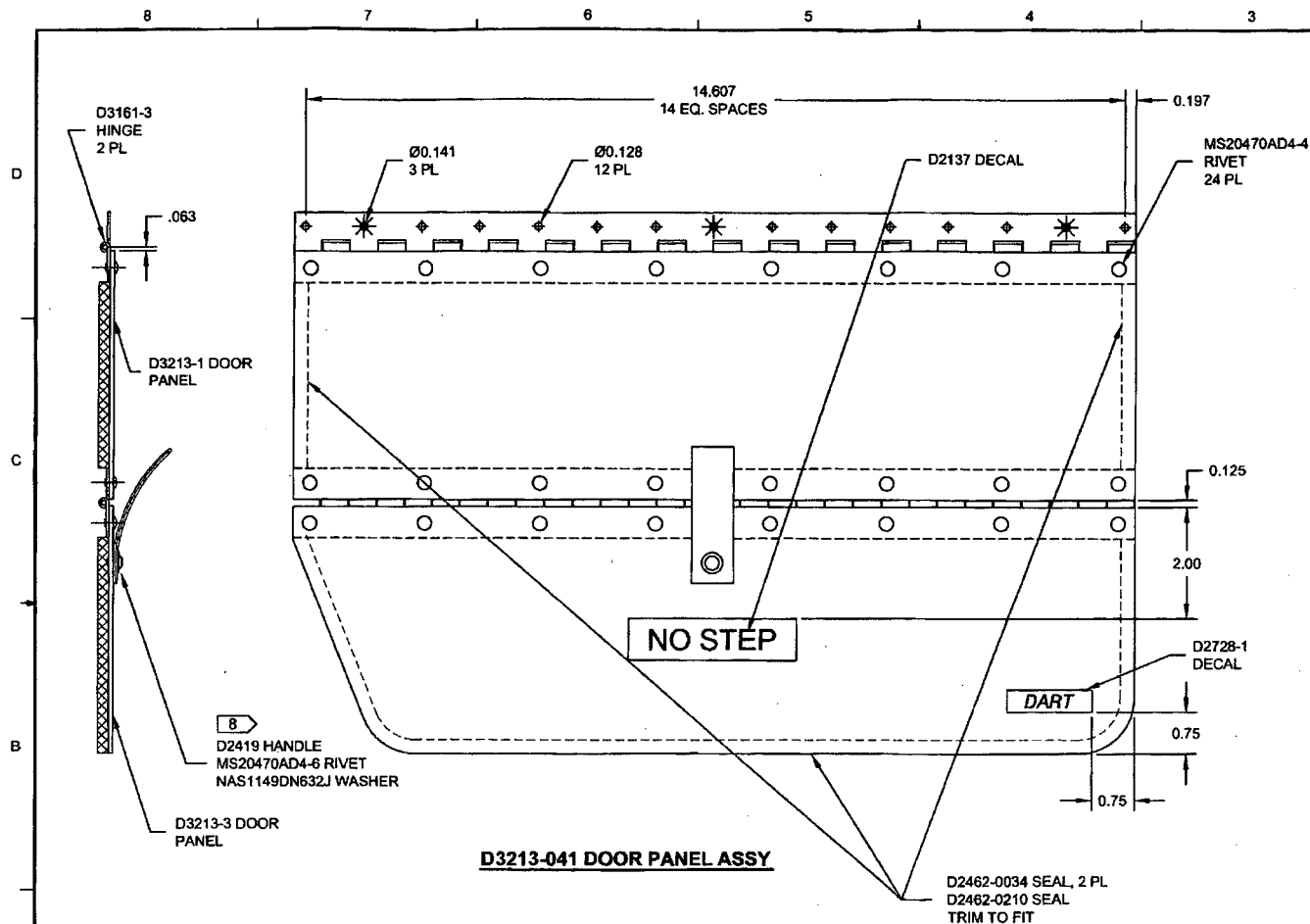
Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
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| Design | | | | | | | | | |
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| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
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| Training | | | | | | | | | |
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| Unapproved | | | | | | | | | |

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|--|--|---|--|



D3213-041 DOOR PANEL ASSY

| QTY -041 | PART NUMBER | DESCRIPTION |
|-------------|---------------|----------------------|
| X | D3213-041 | DOOR ASSEMBLY |
| 1 | D2419 | HANDLE |
| 2 | D2462-0034 | SEAL |
| 1 | D2462-0210 | SEAL |
| 1 | D2728-1 | DECAL |
| 1 | D2137 | DECAL |
| 2 | D3161-3 | HINGE |
| 1 | D3213-1 | DOOR PANEL |
| 1 | D3213-3 | DOOR PANEL |
| 1 | NAS1149DN632J | WASHER (OR AN960JD6) |
| 24 | MS20470AD4-4 | RIVET |
| 1 | MS20470AD4-6 | RIVET |

115109 MLS
14-03-19

RELEASED
2011-06-14

D3213-041 NOTES:

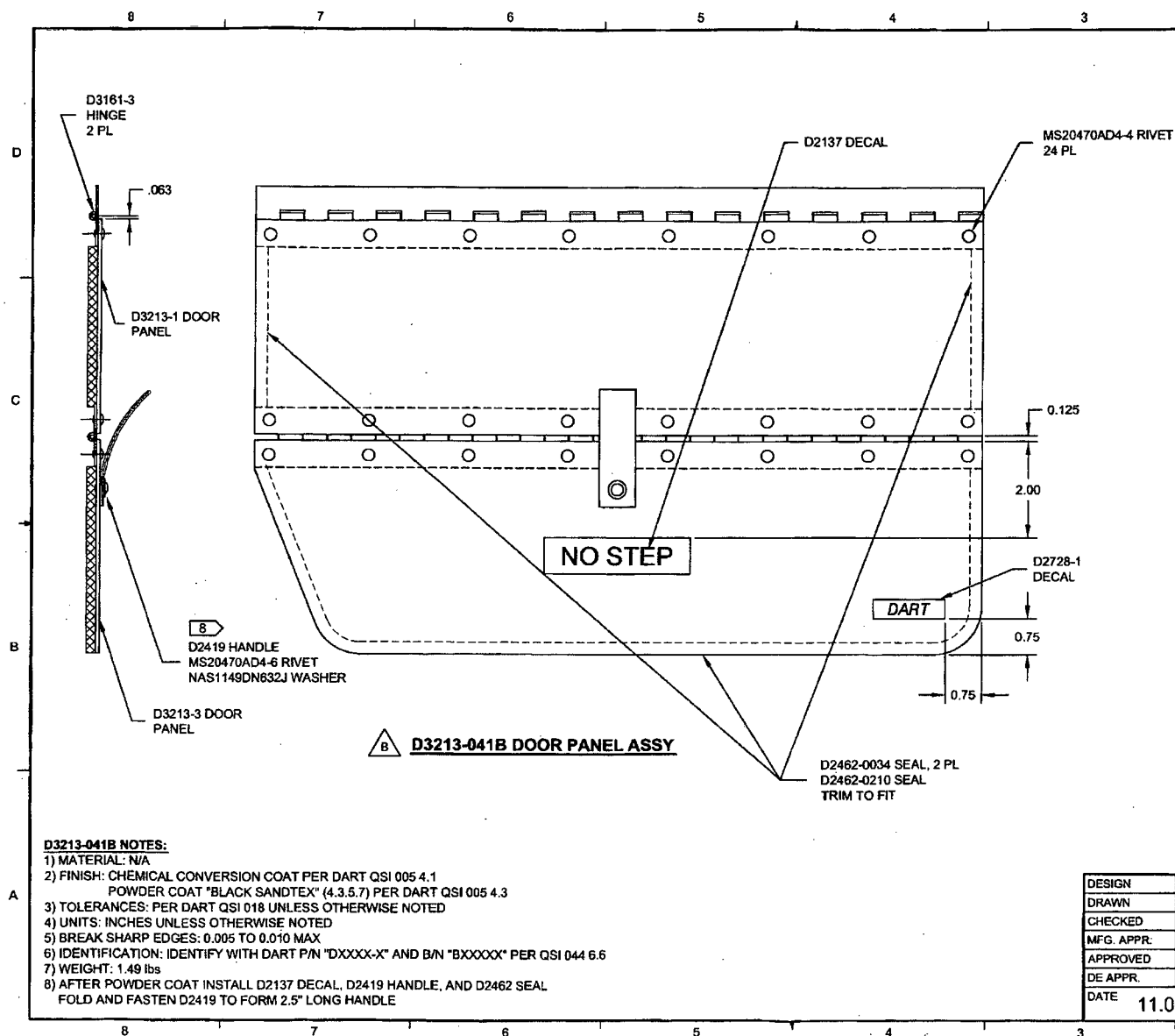
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" AND B/N "BXXXX" PER QSI 044 6.6
- 7) WEIGHT: 1.49 lbs
- 8) AFTER POWDER COAT INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL
FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

| | | | |
|------------|---|----|----------|
| B | FORMAT TO CURRENT STD; ADD D3213-041B REASON: PAR11-109. | MB | 11.06.06 |
| A | NEW ISSUE | CP | 03.09.03 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 11.06.06 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3213
TITLE DOOR ASSEMBLY
REV. B
SHEET 1 OF 4
SCALE NTS

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| QTY | PART NUMBER | DESCRIPTION |
|-------|---------------|----------------------|
| -041B | | |
| X | D3213-041B | DOOR ASSEMBLY, BLANK |
| 1 | D2419 | HANDLE |
| 2 | D2462-0034 | SEAL |
| 1 | D2462-0210 | SEAL |
| 1 | D2728-1 | DECAL |
| 1 | D2137 | DECAL |
| 2 | D3161-3 | HINGE |
| 1 | D3213-1 | DOOR PANEL |
| 1 | D3213-3 | DOOR PANEL |
| 1 | NAS1149DN632J | WASHER (OR AN960JD6) |
| 24 | MS20470AD4-4 | RIVET |
| 1 | MS20470AD4-6 | RIVET |

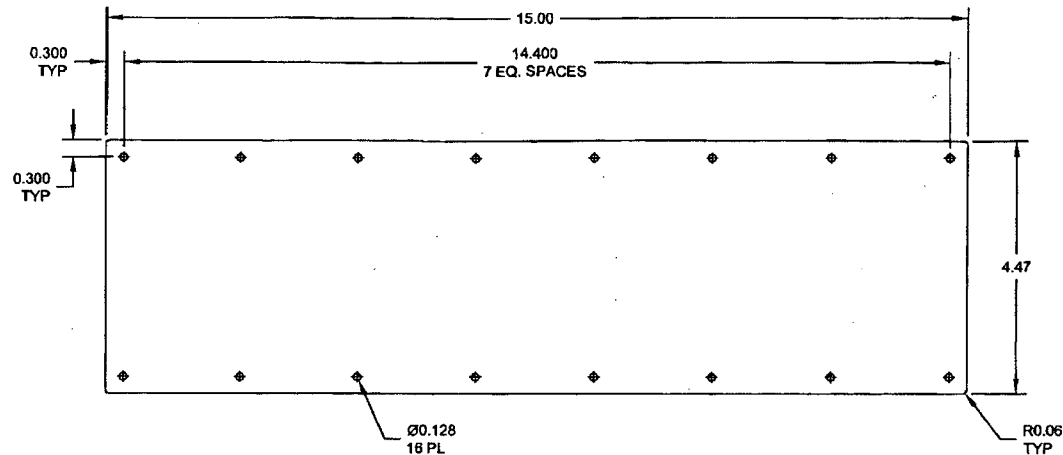
D3213-041B DOOR PANEL ASSY

D3213-041B NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" AND B/N "BXXXX" PER QSI 044 6.6
- 7) WEIGHT: 1.49 lbs
- 8) AFTER POWDER COAT INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL
FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

RELEASED
2011-06-14

| | | | |
|------------|----------|--|--------------|
| DESIGN | 9P | DART AEROSPACE LTD | |
| DRAWN | CP | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | CP | DRAWING NO. D3213 | REV. B |
| MFG. APPR. | CP | | SHEET 2 OF 4 |
| APPROVED | CP | TITLE DOOR ASSEMBLY | SCALE |
| DE APPR. | CP | | NTS |
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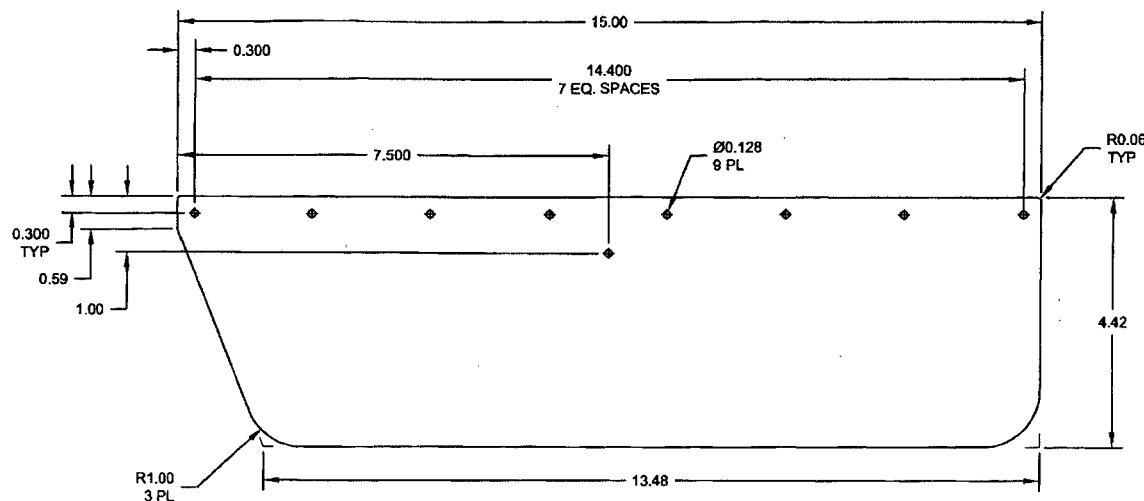
D3213-1 DOOR PANEL

RELEASED
2011-06-15

D3213-1 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF. DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.42 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3213 | SHEET 3 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | DOOR ASSEMBLY | NTS |
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D3213-3 DOOR PANEL

RELEASED
2011-06-10
NR

D3213-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF. DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.39 lbs

| | | | |
|------------|----------|---|--------------|
| DESIGN | 41 | DART AEROSPACE LTD | |
| DRAWN | h | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | Q | DRAWING NO. | REV. B |
| MFG. APPR. | B | D3213 | SHEET 4 OF 4 |
| APPROVED | MP | TITLE | SCALE |
| DE APPR. | # | DOOR ASSEMBLY | NTS |
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